

**Work Order ID 72293**

Page 1

Thursday, July 21, 2011 10:03:57 AM

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-07-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2580-041

Rev.D, DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

*N/A [Signature]*

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

*3 8E11/08/22  
SAD 11-08-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*DP*

11-8-23

*1 8 BEA/08/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004  
A/R□□□ Aluminum Rod

M115778

BE 11/08/23

2-Grind welds on step as per Dwg D2580

BE 11/08/23

3-Weld spacers as per dwg D2580

BE 11/08/23

A/R M115778

3- \*\*\* N/A\*\*\*\* Insert D4202-1 spacer, swage as per QSI002 and trim/ grind  
flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2  
x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Deburr

BE 11/08/23

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Item Name: Replacement Skidtube

Start Date: 7/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8 w/08/24

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5 w/08/24

(40)

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

IX 08/11/08/29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30  
320 OF  
8:00

H O M-L 11/08/30

190

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 O M-L 11/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



HandFinish

Hand Finishing

**Memo**

0.00

1-Install inserts &amp; wearplates &amp; Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1118393

Sikaflex expire date: 12/05

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step &amp; Aft Cap with

Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1118393

Sikaflex expire date: 12/05

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 1118393

1 0 11/108/36

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 7/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Subtotal

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

0.00

PP 72994

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

11/9/13

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/9/14

MF  
11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 1

Thursday, July 21, 2011 10:04:03 AM

Work Order ID: 72293

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube




Start Date: 7/21/2011

Required Date: 8/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30  
KJ IPP Rev P 10.02.19  
per PAR09-043 EC verified by:DD  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q  
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1  Spacer	D2579	Manufactured	No			140	Each	443.0000	20	20			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG002</div> <div>443</div> <div></div> </div>													
<div> <div>66929</div> <div>106</div> <div></div> </div>													
<div> <div>67129</div> <div>196</div> <div></div> </div>													
<div> <div>67308</div> <div>1</div> <div></div> </div>													
<div> <div>67430</div> <div>140</div> <div></div> </div>													
D2580-1  205 Skidtube bent detail		Manufactured	No			110	Each	4.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>4</div> <div></div> </div>													
<div> <div>71014</div> <div>2</div> <div></div> </div>													
<div> <div>71784</div> <div>2</div> <div></div> </div>													
D2576-3  Step (maching detail)		Manufactured	No			140	Each	44.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>44</div> <div></div> </div>													
<div> <div>66156</div> <div>44</div> <div></div> </div>													

BEU/08/23  
8 72672 \*20

BEU/08/22  
8 72840 \*1

BEU/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 72293

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/21/2011

Required Date: 8/10/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

37.0000 1 1



Cap



u/08/31

Location

Loc Qty

Loc Code

FP007

37

53791

2

65519

2

65569

33

AN3-5A

Purchased No

200 Each

1,051.000 2 2



u/08/31

Bolt

Location

Loc Qty

Loc Code

ST350

1051

115371

275

117423

776

AN960JD10L

NAS1149D0332J

Purchased No

200 Each

0.0000 2 2



u/08/31

Washer

ALS7-1032-130

Purchased No

200 Each

899.0000 50 50



u/08/31

Insert

Location

Loc Qty

Loc Code

ST282

899

117717

899

M118237

X50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/21/2011

Required Date: 8/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 1,452.000 50 50



BOLT



11/08/31

Location

Loc Qty

Loc Code

ST350

1452

117313

2

11718628

x50

117688

388

117795

500

117872

22

118012

500

118112

40

AN960C10L Purchased No 200 Each 0.0000 50 50

NAS1149C0332

R



washer

1118354



(x50) 11/08/31

D3566-13 Manufactured No 200 Each 19.0000 1 1



Gasket



11/08/31

Location

Loc Qty

Loc Code

FP

18

69281

18

1372149

x1

FP014

1

68341

1

D3566-5 Manufactured No 200 Each 18.0000 1 1



Gasket



11/08/31

Location

Loc Qty

Loc Code

FP015

18

68961

6

1372849

x1

71601

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 7/21/2011

Required Date: 8/10/2011



Start Qty: 1.00

Required Qty: 1.00

D3566-1      Manufactured      No      200      Each      28.0000      2      2  
   ML 11/08/31  
 Gasket



Location      Loc Qty      Loc Code

FP011	26	B72848	<u>XL</u>
70769	14		
71580	12		
FP015	2		
68924	2		

D3564-11      Manufactured      No      200      Each      12.0000      1      1  
  ML 11/08/31  
 Wearshoe



Location      Loc Qty      Loc Code

FP019	12	B72207	<u>XL</u>
67591	12		

D3564-13      Manufactured      No      200      Each      20.0000      1      1  
  ML 11/08/31  
 Wearshoe

Location      Loc Qty      Loc Code

FP016	9		
69280	9		
FP017	11		<u>XL</u>
71594	11		

D3564-9      Manufactured      No      200      Each      14.0000      1      1  
  ML 11/08/31  
 Wearshoe

Location      Loc Qty      Loc Code

FP019	14	B72208	<u>XL</u>
67590	4		
69943	10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Replacement Skidtube

Start Date: 7/21/2011

Required Date: 8/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

17.0000

1

1



Wearshoe



Handwritten: 11/08/31

Location

Loc Qty

Loc Code

FG

2

34806

2

B72164

Handwritten: X1

FP019

15

70864

15

D2594-3

Manufactured No

200

Each

740.0000

16

16



O-Ring, 205 Skidtube



Handwritten: 11/08/31

Location

Loc Qty

Loc Code

FP-A

740

65518

54

66952

686

Handwritten: X16

D2594-1

Manufactured No

200

Each

201.0000

16

16



Plug, 205 Skidtube



Handwritten: 11/08/31

Location

Loc Qty

Loc Code

FP-A

201

42807

28

67441

7

68943

166

B72123

Handwritten: X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07.06.28 *PH***DEO ATTACHED****UNDER REVIEW***P110670*RMV *P11.06.70*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *72293*  
*P11-07-21***GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

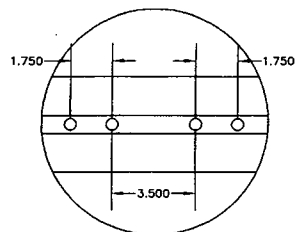
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

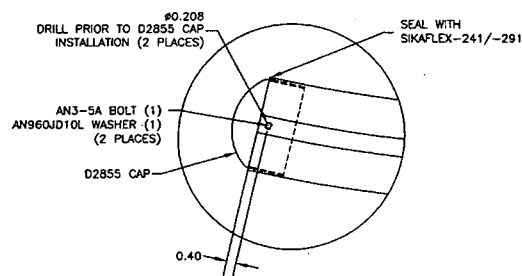
**DETAIL A**  
SCALE 5:24



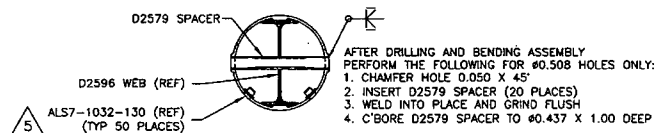
RELEASED  
07-06-28

~~DEO ATTACHED~~

**DETAIL C**  
SCALE 5:24



**SECTION D-D**  
SCALE 5:24



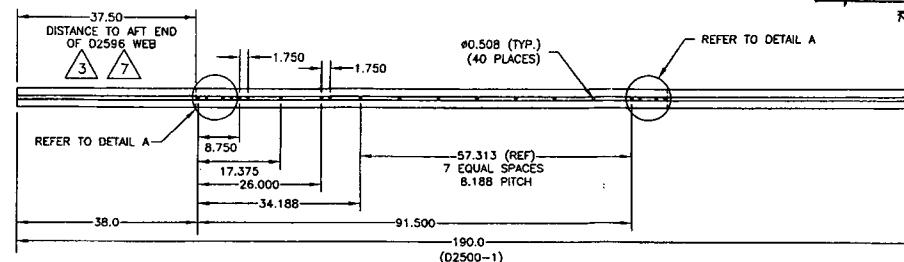
**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

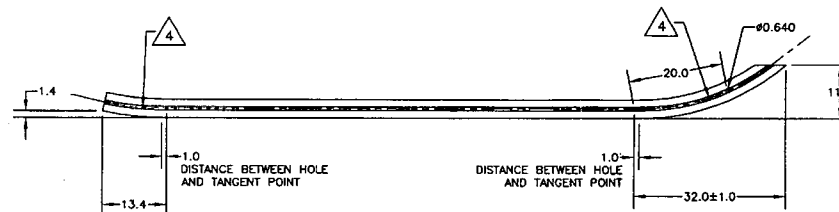
~~UNDER REVIEW~~

CP 11.06.30  
RMV CP 11.06.30

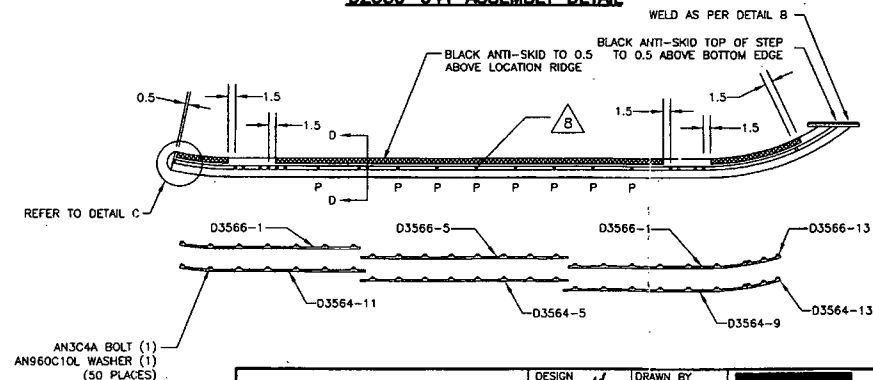
**D2580-1 DRILLING DETAIL**



D2580-1 BENDING AND CUTTING DETAIL



**D2580-041 ASSEMBLY DETAIL**



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

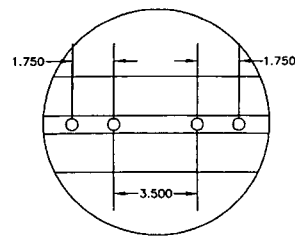
**NOTE:** Date & initial all entries

72293

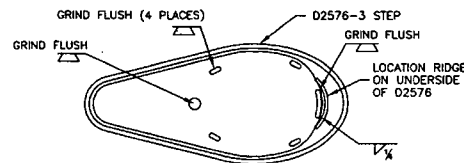
UNDER REVIEW

17.06.30  
RMV 4/11/03

DETAIL E  
SCALE 5:24



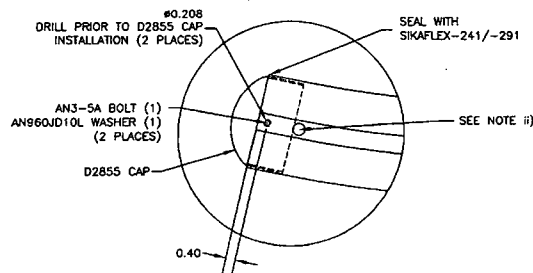
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SCALE 5:24



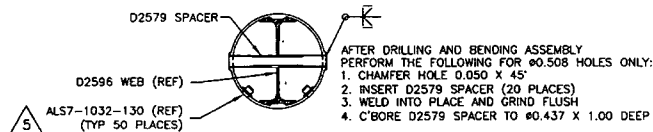
RELEASED  
07.06.18

DEO ATTACHED  
RMV 4/11/03

DETAIL G  
SCALE 5:24

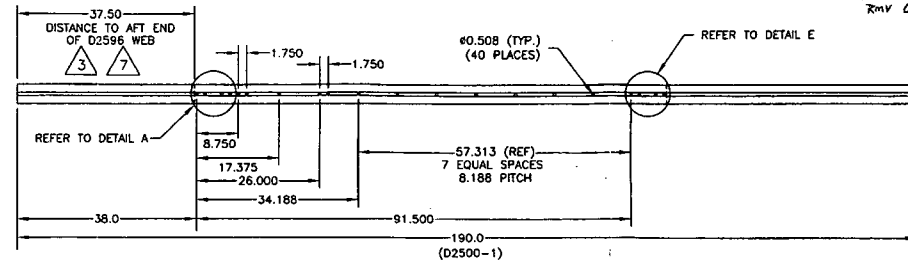


SECTION H-H  
SCALE 5:24

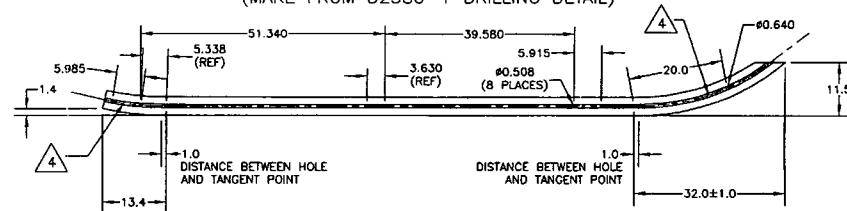


- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2579 SPACER (20 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

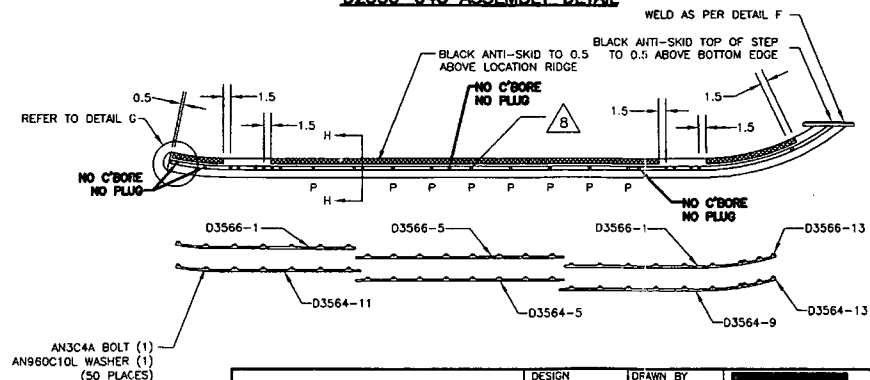
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL  
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN  
CHECKED  
DATE  
07.02.27

DRAWN BY  
APPROVED

DART  
DART AEROSPACE LTD.  
MARKHAM, ONTARIO, CANADA  
DRAWING NO.  
D2580  
TITLE  
205 SKIDTUBE ASSEMBLY  
REV. D  
SHEET 3 OF 3  
SCALE  
1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 262

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: B71946  
Part number: D205 634 041  
Description: 205  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Sal. Burns Date of Test Coupon 11-08-11  
Welder Barclay Elliott Date of Test Coupon 11-08-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld